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(54) **Title:** A NOVEL PROCESS FOR PREPARATION OF NEBIVOLOL INTERMEDIATES

(57) **Abstract:** The present invention relates to a process for separation of desired diastereomeric pair from a mixture of diastereomeric pairs thereby obtaining nebivolol intermediates. Thus, the mixture of (+)-[1S*(R*)]-6-fluoro-3,4-dihydro-α-[[(phenylmethyl)amino]methyl]-2H-l-benzopyran-2-methanol, (+)-[1S*(S*)]-6-fluoro-3,4-dihydro-2-oxiranyl-2H-l-benzopyran and ethanol is heated to reflux temperature and stirred for 8 hours at the same temperature to obtain (±)-[2R*[1S*,5S*(S*)]]+[2R*[1S*,5R*(R*)]]- α,α'-[phenylmethyliminobis(methylene)]bis[6-fluoro-3,4-dihydro-2H-l-benzopyran-2-methanol]. Then the reaction mass is cooled to 10°C, the pH is adjusted to 2 with HCl gas and stirred for 45 minutes at 25°c to 30°C. Then the separated solid is filtered and dried to give (+)-[2R*[1S*,5S*(S*)]]- α,α'-[phenylmethyliminobis(methylene)]bis[6-fluoro-3,4-dihydro-2H-l-benzopyran-2- methanol] hydrochloride salt, which can be converted into nebivolol.

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